

Date: Thursday, 22/03/2007 3:20:00 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CONSOLE SIDE LH (206 HI-SLOPE)
Job Number	: 31332		
Estimate Number	: 11000		
P.O. Number	: N/A	Part Number	: D26021
This Issue	: 22/03/2007 S.O. No. : N/A	Drawing Number	: D2602 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: A1
Previous Run	: 31332	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 10/04/2007 Qty: 10 Um: Each
Checked & Approved By	: <u>[Signature]</u>		
Comment	: Est. D 04.02.25 Reformat KJ/RF Note: Issue with part number D2602-2 Est Rev:E Now On Waterjet 07-03-22 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S040	2024-T3 .040 sheet
-----	-------------	--------------------



Comment: Qty.: 1.4146 sf(s)/Unit Total : 14.1456 sf(s)
2024-T3 .040 sheet
Material: 2024-T3 (QQ-A-250/4) 0.040" thick
(M2024T3S.040) Batch M104025

SAD 07/04/14

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
1-Cut as per Dwg D2602
*****Same Cutting File for -1 & -2 *****
Dwg Rev: A1
Prog Rev: A1
2-Deburr if necessary

SAD 07/04/14 (10)
S/M 07/04/24 60

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/04/14 (10)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SAD 07/04/14 (10)

Date: Thursday, 22/03/2007 3:20:00 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE SIDE LH (206 HI-SLOPE)

Job Number: 31332

Part Number: D26021

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

SAD 07/04/24 (10)

Form as per Dwg D2602

SB 07/05/03

(10)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10/05/04 (10)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FF 07-05-04

10

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 07/05/04

(10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

FF 07-05-04

10

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SB 07/05/04

(10)

Job Completion



U 07/05/04

Date: Tuesday, 3/20/2007 12:03:28 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CONSOLE SIDE LH (206 HI-SLOPE)
Job Number	: 31333		
Estimate Number	: 11001		
P.O. Number	:	Part Number	: D26022
This Issue	: 3/20/2007 S.O. No. :	Drawing Number	: D2602 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A1
Previous Run	: 25472	Material	:
Written By	:	Due Date	: 4/10/2007 Qty: 10 Um: Each
Checked & Approved By	: <u>4/07.03.20</u>		
Comment	: Est. E 04.02.25 Reformat KJ/RF		
	Note: Issue with part number D2602-1		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M2024T3S040

2024-T3 .040 sheet



Comment: Qty.: 1.4146 sf(s)/Unit Total : 14.1456 sf(s)
2024-T3 .040 sheet
Material: 2024-T3 (QQ-A-250/4) 0.040" thick
(M2024T3S.040) Batch _____

W. H. Taylor

2.0

SHEAR

SHEAR



Comment: SHEAR
Cut Blank per template DT8243

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA145 and Dwg D2602
Stack of 10
Identify as D2602-2

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

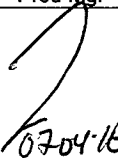

QC8

SECOND CHECK



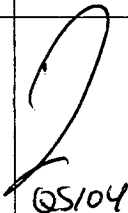



Comment: SECOND CHECK

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07.04.16	2.0	Add a grain direction to the bag ^{or w/o} along opposite to 13.699". Permanent change				 07.04.16	 07.04.16	

Part No: D2602-2 PAR #: N/A Fault Category: Prod / Prod Ass. mfg NCR: Yes No DQA: 12 Date: 07/05/07
QA: N/C Closed: 12 Date: 07/05/08

NCR: <u>31333</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/04/14	2.0	Hole's were to big because Jet offset was at 0.022" suppose to be at 0.015" Program fault 1 SCRAP	 05/10/12	Scrap & destroy, Replace	SAD 07/04/14	 07/04/16	 05/10/12	 07/04/16

NOTE: Date & initial all entries

Date: Tuesday, 3/20/2007 12:03:28 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE SIDE LH (206 HI-SLOPE)

Job Number: 31333

Part Number: D26022

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

Form as per Dwg D2602

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

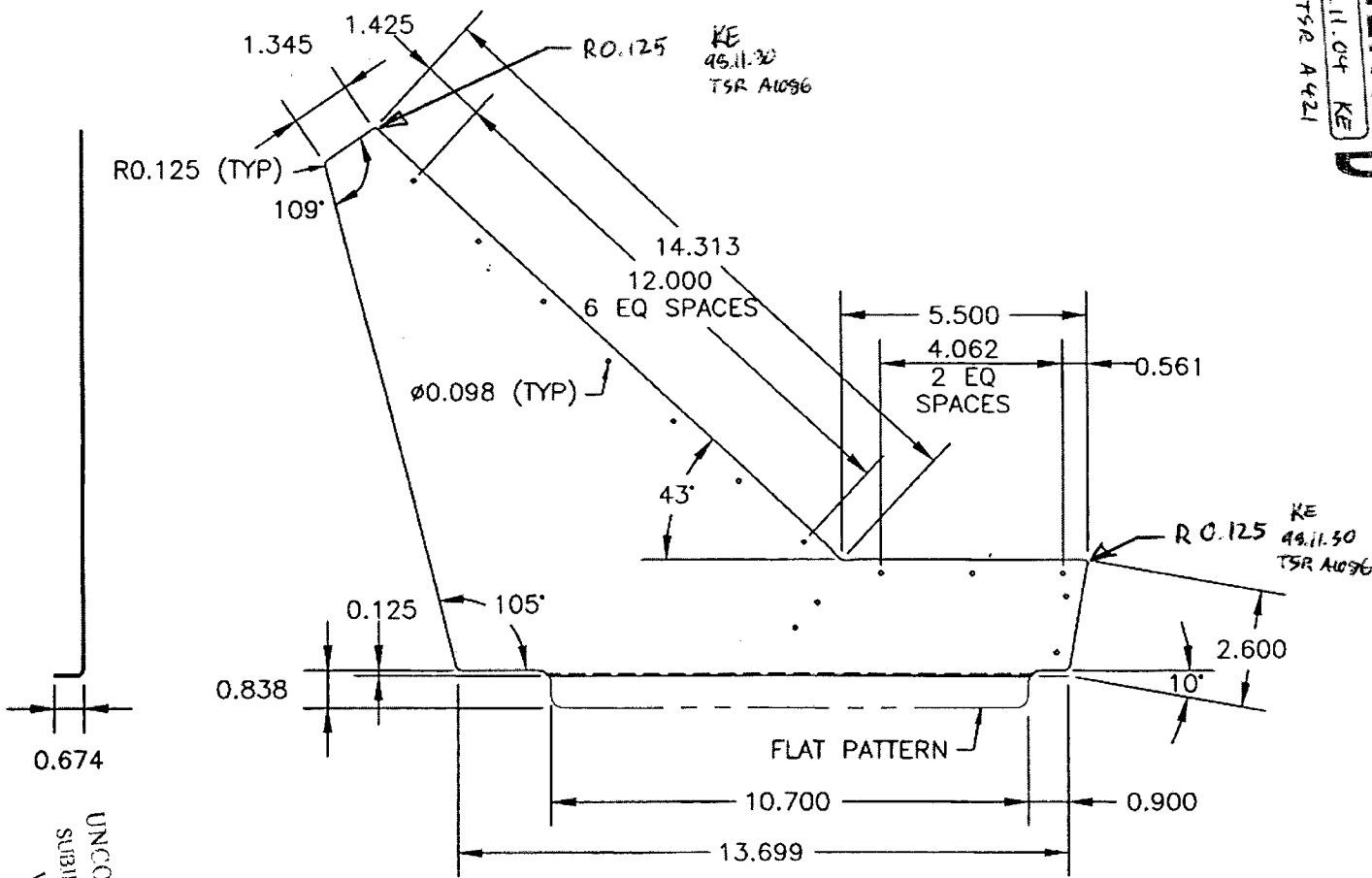
NOTE: Date & initial all entries

DART



RELEASED
97.11.04 KE
TSR A421

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
KE	BW	DRAWING NO.	REV. A
KE	APPROVED	D2602	SHEET 1 OF 1
DATE		TITLE	SCALE
97.10.22		CONSOLE SIDE	1:4
A	97.10.22	D2602 WAS D206-547-21/	
AI	02.06.04	ADD FINISH	



MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
PROFILE CONTROLLED BY FOLIO H2602
BEND RADIUS 0.093
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 605 4.1
D2602-1 SHOWN
D2602-2 OPPOSITE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 313333

DART AEROSPACE LTD	Work Order:	31333
Description: CONSOLE SIDE LH	Part Number:	D2602-1/2
Inspection Dwg: D2603 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

[illegible]

Measured by:	JAN	Audited by:	[Signature]	Prototype Approval:	N/A
Date:	07/04/14	Date:	07/04/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	